

Date: Wednesday, 3/14/2007 3:27:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 204 STEP LUG
 Job Number : 31210
 Estimate Number : 11844
 P.O. Number : N/A Part Number : D23382
 This Issue : 3/14/2007 S.O. No. : N/A Drawing Number : D2338 REV B U/R
 Prsht Rev. : NC Project Number : N/A
 First Issue : 3/14/2007 Type : MACHINED PARTS Drawing Revision : B
 Previous Run : Material : N/A
 Written By : Due Date : 3/23/2007 Qty: 6 Um: Each
 Checked & Approved By :
 Comment : Est. B00.03.24 Separated -1 from -2 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 0.3827 f(s)/Unit Total: 2.2964 f(s)

6061-T6 Bar .50" x 6.0"

* Material: 6061-T6 0.5 x 6.0"

Batch: 1103436

1 blank makes one D2338-1 & one D2338-2

07/03/19

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks 8.75" long

07/03/19

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2338

Tumble & Deburr

SA / 07/03/19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / 07.03.20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/20

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 204 STEP LUG

Job Number: 31210

Part Number: D23382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/13/22 (5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



07/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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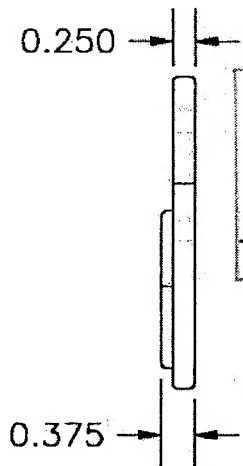
NOTE: Date & initial all entries



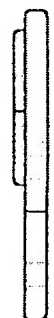
DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	<i>B</i>	APPROVED	<i>B</i>	DRAWING NO. D2338	SHEET 1 OF 1
DATE	95:01:25	TITLE	ENDPLATE	RE-DESIGN AND ADD D2338-2	SCALE 1:2
B	96.03.29				

RELEASED
97/04/22

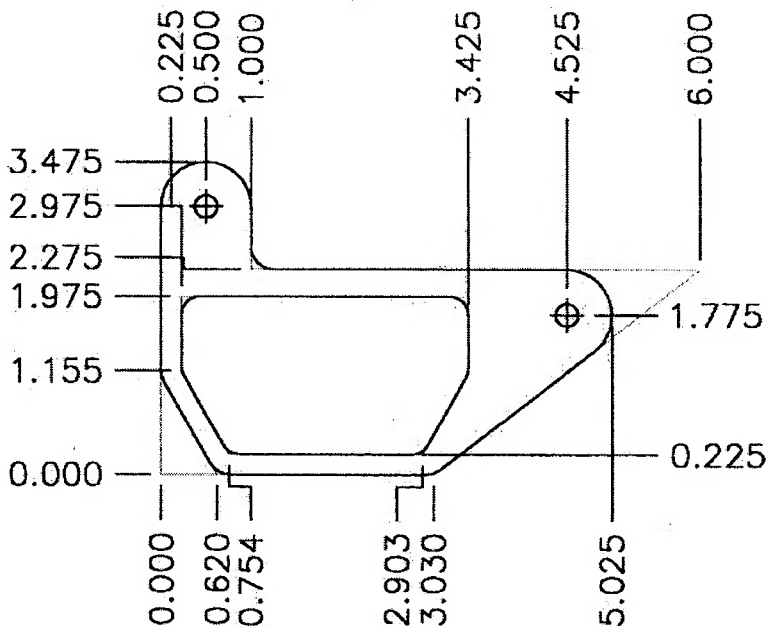
UNDER REVIEW



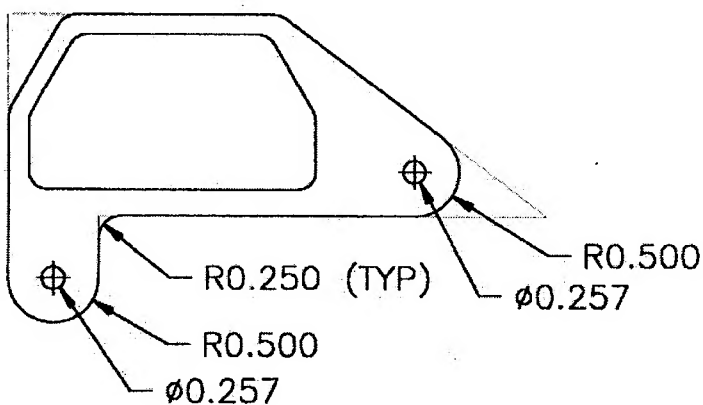
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

DART AEROSPACE LTD		Work Order: 31210
Description: 204 Step Lgs		Part Number: 02338-2
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A						
B						
C						
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SA	Audited by: J.F.	Prototype Approval:	N/A
Date: 07-03-20	Date: 07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	